



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-11-1
Job Sheet 193431



Part No: C45-11-1

Job Qty: 10 pcs

Part Name: Sideplate, Solenoid Side



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/15/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/24/19

Description:

Type: Stock

Note: DWG C45-11-1 REV 12 IPP REV A 18.02.14 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	10 pcs	5/24/19	5/24/19	0.00	1.67	Bandsaw - 1	PS 19-05-03
120	NV5000 - 1 - B4B	10 pcs	5/24/19	5/24/19	0.00	5.00	NV5000 - 1 - B4B	PS 19-05-03
							NV5000 - 2 - B4B	PS 19-05-03
130	QC 2	10 pcs	5/24/19	5/24/19	0.00	0.00	QC 2 - 1	PS 19-05-03
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	PS 19-05-09
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S177609



Part: C45-11-1

Job No: 193431

Serial No/Batch: S177609

Revision: 12

Inspector:

Exp Date:

Instructions:

Date: 05/03/19

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140 QC 8	10 pcs	5/24/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	2019/05/12
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Outsource - 4 - Anodize	10 pcs	5/24/19	0.00 0.00	ATG001	2019-05-13
160 Packaging 2-1 - Receive - B4B	10 pcs	5/24/19	0.00 0.00	Packaging 2 - 1 - B4B	MAY 21 2019
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	

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					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170 QC 6	10 pcs	5/24/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
180 Packaging 3-1 - Stock - B4B	10 pcs	5/24/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	5/24/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	JUN 28 2019 70
					QC 21 - SA - 53	9-89

Part Op **100** - (Bandsaw) 1- Cut 9.325" long
 Descriptions: **120** - 1-Machine as per folio FC712 FOLIO REV: AA DWG REV: 12 2-Machine Engrave S/N 3-
 Debur
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
150 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech : 43446 -ANODIZE
 COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required
160 - (Receive & Inspect for Damage & Mat'l Certs) Receive
170 - (QC6- All purchased or subcontracted products)
180 - (Identify as per dwg & Stock Location: _____) Identify and Stock
190 - (QC21- Final Inspection - Work Order Release)

MAT
used
8.587

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X8.000	7075-T6 Sheet 1.000" X 8.000"	7.7700 ft (.777 ea)	100-Bandsaw - 1	SO 81264
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X8.000	8	19	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	193431
Description: side plate, solenoid side		Part Number:	C45-11-1
Inspection Dwg:	Rev: 12	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10-22	90/10 90	60	✓		90/10 90	
Ø.177	-.001 / +.004	.177	✓		pin	
Ø.1875	low / +.0005	.1870	✓		pin	
Ø.500	-.000 / +.0005	.501	✓		pin	
Ø.1000	-.000 / +.0005	1.000	✓		pin / TG	TG - Telescopic gage
Ø.520	-.000 / +.0003	.522	✓		dial gage	
Ø.3125	-.000 / +.0005	.314	✓		pin	
4-40	90/10 90	90	✓		90/10 90	
1/4-28	90/10 90	90	✓		90/10 90	
Ø.25	-.001 / +.0005	.250	✓		pin	
Ø.125	-.000 / +.0004	.125	✓		pin	drill changed to .1280
Ø.500	-.001 / +.0006	.499	✓		pin	
Ø.570 82°	H/- .0005	.570	✓		PS 05	
Ø.8751	-.000 / +.0003	.8751	✓		pin / TG	
Ø.470	-.000 / +.0003	.472	✓		dial gage	
Ø.2513	-.000 / +.0009	.2515	✓		pin	
Ø.9050	-.000 / +.0005	.9050	✓		pin / TG	
Ø.720	-.000 / +.0005	.722	✓		dial gage	
Ø.6250	-.000 / +.0005	.6250	✓		pin / TG	
Ø.470	-.000 / +.0003	.472	✓		dial gage	
Ø.400	-.000 / +.0003	.402	✓		dial gage	
Ø.840	H/- .0005	.838/.841	✓		PS 01	
Ø.540	H/- .0005	.541	✓		PS 01	
Ø.440	H/- .0005	.439/.444	✓		PS 01	
Ø.370	H/- .0005	.372	✓		PS 01	
Ø.170	H/- .0005	.170	✓		PS 01	
Ø.07 chamfer	H/- .010	.070	✓		PS 05	
Ø.03	H/- .010	.030	✓		dial gage	

Measured by: PJ	Checked by: [Signature]	QC Inspector:
Date: 19-05-03	Date: 19/05/12	Date:

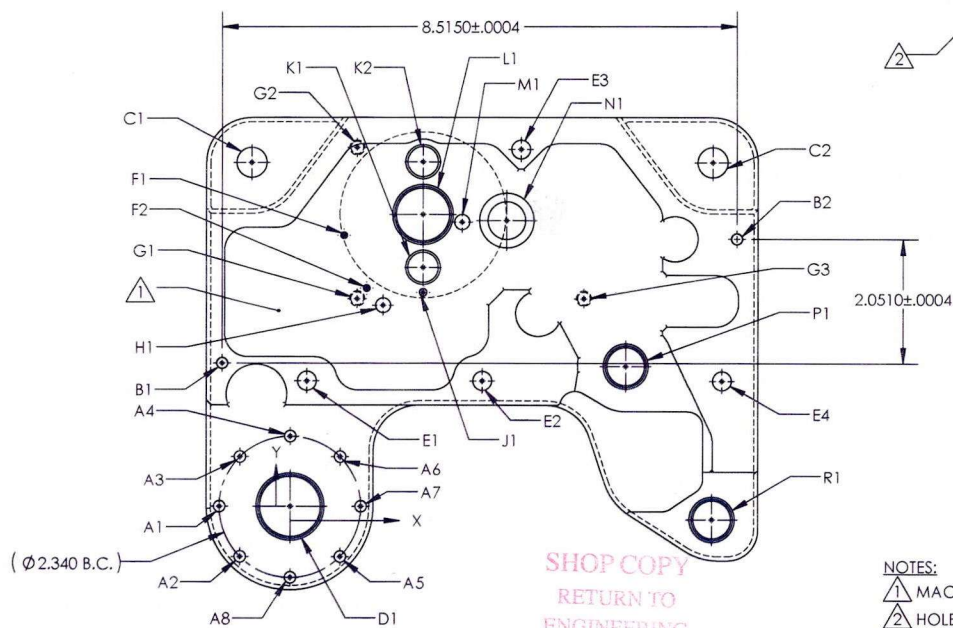
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

TAG	X LOC	Y LOC	
A1	-1.170	.000	10-32 UNF - 2B THRU ALL
A2	-.827	-.827	
A3	-.827	.827	
A4	.000	1.170	
A5	.827	-.827	
A6	.827	.827	
A7	1.170	.000	
A8	.000	-1.170	
B1	-1.125	2.379	ϕ .177 THRU ALL └─ ϕ .1875 $\begin{smallmatrix} +.0000 \\ -.0005 \end{smallmatrix}$ ▾ .55
B2			
C1	-.636	5.695	ϕ .500 $\begin{smallmatrix} +.005 \\ -.000 \end{smallmatrix}$ THRU ALL
C2	6.989	5.695	
D1	.000	.000	ϕ 1.000 $\begin{smallmatrix} +.0005 \\ -.0000 \end{smallmatrix}$ THRU ALL └─ ϕ 1.125 ▾ .520 $\begin{smallmatrix} +.003 \\ -.000 \end{smallmatrix}$
E1	.273	2.087	ϕ .3125 $\begin{smallmatrix} +.0050 \\ -.0000 \end{smallmatrix}$ THRU ALL
E2	3.177	2.087	
E3	3.818	5.913	
E4	7.142	2.087	
F1	.890	4.487	4-40 UNC - 2B ▾ .712
F2	1.264	3.613	
G1	1.105	3.445	
G2	1.105	5.945	
G3	4.855	3.445	ϕ .213 ▾ .375 1/4-28 UNF - 2B ▾ .339 FAR SIDE
H1	1.537	3.333	ϕ .250 THRU ALL
J1	2.194	3.545	ϕ .129 .125 ▾ .6
K1	2.194	3.958	ϕ .500 THRU ALL ✓ ϕ .570 X 82°
K2	2.194	5.708	
L1	2.194	4.833	ϕ .8754 .8751 THRU ALL └─ ϕ 1.000 ▾ .470 $\begin{smallmatrix} +.003 \\ -.000 \end{smallmatrix}$
M1	2.842	4.709	ϕ .2522 .2513 ▾ .700
N1	3.582	4.734	ϕ .625 ▾ .760 └─ ϕ .9055 $\begin{smallmatrix} +.005 \\ -.000 \end{smallmatrix}$ THRU ALL .9050 ▾ .720 $\begin{smallmatrix} +.003 \\ -.000 \end{smallmatrix}$
P1	5.550	2.326	ϕ .6250 $\begin{smallmatrix} +.0005 \\ -.0000 \end{smallmatrix}$ THRU ALL └─ ϕ .750 ▾ .470 $\begin{smallmatrix} +.003 \\ -.000 \end{smallmatrix}$
R1	6.977	-.213	ϕ .6250 $\begin{smallmatrix} +.0005 \\ -.0000 \end{smallmatrix}$ THRU ALL └─ ϕ .750 ▾ .540 $\begin{smallmatrix} +.003 \\ -.000 \end{smallmatrix}$

ASSY QTY	ASSY QTY	B/O	Part #	UNIT	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-11-1	1	SIDE PLATE SOLENOID	7075-T6	

REVISIONS								
REV	ECR	DESCRIPTION				DATE	INITIAL	APPROVE
8		AS DRAWN BY CANAM.				9/12/2012	JAG	
9		CHD HOLE TOLERANCES FOR B1 & B2, E1-E4, J1, K1 & K2, L1 AND N1FOR BETTER FITS.				9/19/2012	JAG	SE
10	14-0126	CHD TITLE BLOCK WAS RED BARN IS DART, ADDED MACHINE ENGRAVE NOTE: CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.				8/13/2014	DPD	RW
11	15-0225	UPDATED HOLE TABLE WAS P2 IS R1, CHD M1 WAS 0.2506-.2508 P.300 IS 0.2513-.2522 P.700, CHD HOLE 0 TO BE CALD FROM SAME SURFACE. DI WAS 0.120 +003-.000 P.520 +003-.000 P1 & F2 WAS 0.312 IS 0.712, J1 WAS 2.05-.6, L1 WAS 0.070 +003-.000 P.470 +003-.000, N1 WAS 0.360 IS 0.760, WAS 0.320 +005-.000 P.720 +005-.000, P1 WAS 0.070 +003-.000 IS 0.470 +003-.000, P1 WAS 0.070 +003-.000 IS 0.540 +003-.000, ADDED HOLE 0 NOTE, ADDED DIMS 1.70, 8.50, DELETED UNNECESSARY DIMS SHEET 2, CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.				9/10/2015	DPD	
12	17-0116	ADDED TO NEW STANDARDS. REMOVED DIM 7.390, 4.430. ADDED DIM 8.5150+.0004, 8.5150-.0004.				5/10/2017	SM	JAG



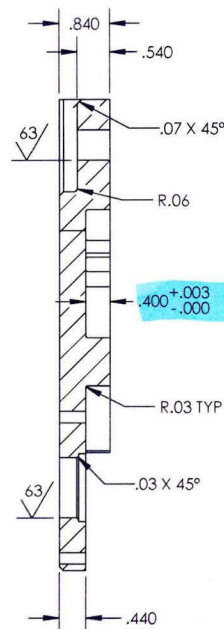
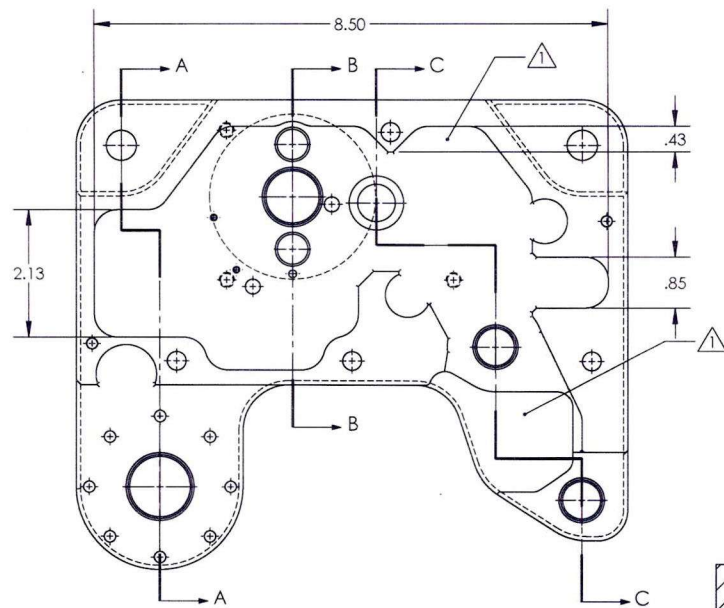
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193431 M.

① MACHINE ENGRAVE BATCH NUMBER.
② HOLE ∇ CALLED FROM THIS SURFACE.

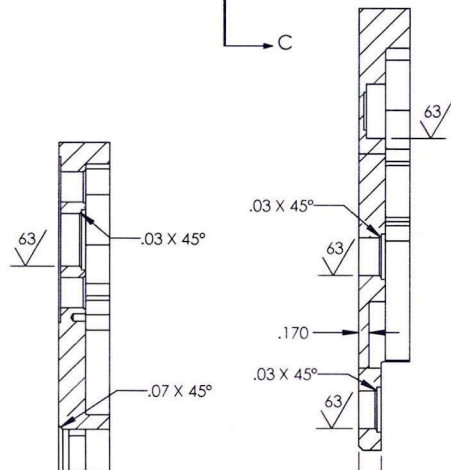


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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
11	15-0225	ADDED DIMS .170, 8.50. DELETED UNNECESSARY DIMS.	9/10/2015	DPD
				JAG

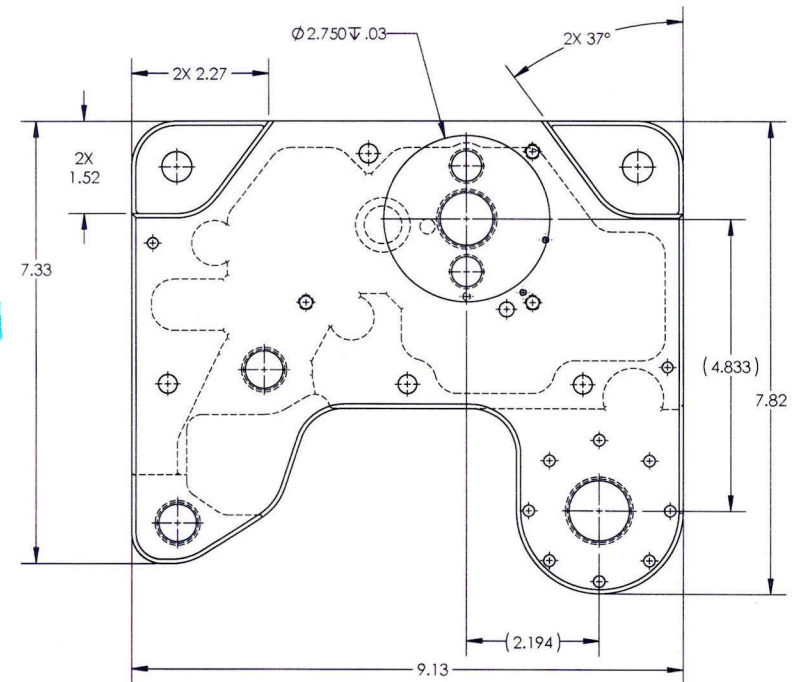


SECTION A-A



SECTION B-B

SECTION C-C



NOTE:

USE DXF PROFILE FOR POCKET DETAILS.

DART AEROSPACE	
TITLE SIDEPLATE - SOLENOID SIDE	
DWG NO C45-11-1	REV 12
MAT'L 7075-T6 FINISH BLACK ANODIZE SPEC MIL-A-8625, TYPE II, CLASS II DRAWN BY: CANAM CHECKED: RJC 05/10/2017 OPQS APPR: AA 05/17/2017 QA APPR: JL 05/24/2017 APPROVED: JAG 05/24/2017 SCALE 1:2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/✓ 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
DATE 4/10/2003	SHEET 2 OF 2

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043446



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043446

PO Date: 5/13/19

Due Date: 5/17/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194047	D2224	Rappel Anchor Assembly : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O: Red Anodize as per Dwg D2224 MIL-A-8625	Firmed X4	-	5/15/19 MAY 17 2019	4 pcs	0 pcs	4 pcs DP	\$7.05/pcs	\$28.20

Line Item Note ****RUSH***

2	193094	RBE350A94-5201-20	Cartridge, Dummy, Fuel (Outsource process- Anodize per QSI017 4.1.10.1), -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	5/17/19 23 X MAY 21 2019	23 pcs	0 pcs	23 pcs B	\$7.05/pcs	\$162.15
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Plex 5/14/19 1:55 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043446



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193431	C45-11-1	Sideplate, Solenoid Side (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	5/17/19	12 pcs	0 pcs	12 pcs	\$7.05/pcs	\$84.60

Grand Total:	\$274.95
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Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/14/19 1:55 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917838

Date: 17-May-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: C45-11-1 Sideplate, Solenoid Side Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils)., Water Sealant Job: 25119 PO: POHB043446	Rev: Line: 3	DAS 61 9-80
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 17 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

RECEIVED

MAY 17 2019

DART AEROSPACE LTD.

Made in Canada.